



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4635-142
Job Sheet 185080



006757

Part No: D4635-142

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4635 REV F SHEET 10 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL verf: DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/18	0.00	0.00	Start Up Small Fab		Smb
110	Small Fab	1 pcs		11/16/18	0.00	0.80	Small Fab		Smb
120	QC	1 pcs		11/16/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3		Smb
140	QC21-SA	1 Ea		11/16/18	0.00	0.00	QC21		DEC 05 2018

Part Op 110 - Assemble as per Dwg D4635-142 Bond foam core to inside of panel 3M Scotch Weld 1300
Descriptions: Batch: MB8775 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # MB8958 Expiry Date april 19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: MB8962
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location:
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-2	Fwd Ceiling Panel, RH	1 Ea (1 ea)	90-Start up Operation	5054526
D4669-1	Bracket	2 Ea (2 ea)	90-Start up Operation	5132879
D4695-042	Channel Assembly, RH	1 Ea (1 ea)	90-Start up Operation	5025805
D4732-3	Label	1 Ea (1 ea)	90-Start up Operation	5060827
D4732-31	Label	1 Ea (1 ea)	90-Start up Operation	5060907
D4732-35	Label	1 Ea (1 ea)	90-Start up Operation	5060910
D4732-7	Label	1 Ea (1 ea)	90-Start up Operation	5008987
D5022-1	Foam, Side Panel, Fwd	1 Ea (1 ea)	90-Start up Operation	5034014

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4635-2	1	3	0
	D4669-1	2	4	0
	D4695-042	1	8	0
	D4732-3	1	6	0
	D4732-31	1	6	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

D4732-35
D4732-7
D5022-1

1
1
1

6
0
3

0
0
0

Part Specifications

Specifications could not be found.

Plex 10/22/18 1:29 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S134539



Part: D4635-142

Job No: 165080

Serial No: 165080

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/04/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								